

Date: Tuesday, 12/05/2009 11:38:21 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L BASKET LID
Job Number : 45544B	
Estimate Number : 11274	
P.O. Number :	Part Number : D2252043
This Issue : 12/05/2009 S.O. No. :	Drawing Number : D2252 REV.G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 47904B	Material :
Written By :	Due Date : 22/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JD 09.05.12</u>	
Comment : Est Rev: I REVISED AS PER REV E 05-12-06 JLM	
Est Rev: J 08-09-09 revF as per dwg (ecn 08-522) DD verified by: EC	
Est Rev K 09.03.18 Rev.G ecn 09-532 EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)
 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch: _____

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- Cut ribs as required and weld as per DWG D2252

3.0	D22211	Rib
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Rib B46338

4.0	D22521	Frame
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Frame B46824

5.0	D22527	Frame
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Frame B46829

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:38:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 45544B

Part Number: D2252043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D225223	Frame
-----	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Frame **B46828**

PD 09-05-21

7.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2327-3	Bushing	B44365
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PD 09-05-21

8.0	D2329	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2329	Label Plate	B35686
---	-------	-------------	---------------

PD 09-05-21

9.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2581	Mounting Chanel	B46086
---	-------	-----------------	---------------

PD 09-05-21

10.0	D298919	Rib
------	---------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Rib **B47954**

PD 09-05-21

11.0	D37491	Hinge Half
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Hinge Half **B38826**

PD 09-05-21

12.0	M304EX07516F	Expanded Metal Flat SS
------	--------------	------------------------



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

18 sf	M304EX0.75-16F	Expanded Metal	M111630
-------	----------------	----------------	----------------

SAM 09-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:38:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 45544B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M108160

AD 09-05-21

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 09-05-22

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/05/25

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M111472
PRESSURE WASH

BR 09-05-25

1st COAT ->

START TIME:

2:45 pm

2ND COAT

START TIME 3:15 pm

OVEN TEMPERATURE:

400°F

oven Temp: 400°F

FINISH TIME:

3:15 pm

FINISH TIME 3:45 pm

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

UMD/BR 09/05/26

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RPP 45544
09/06/01

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/01

Job Completion



MF 09-06-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-05-14	13	Drill hole in 2252-1 as per Dwg 2252 and weld D2327-3					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

G

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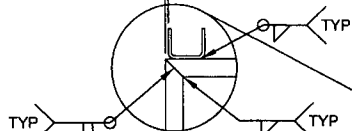
NOTES:

- FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: N/A
- WELDING: PER DART QSI 004

RELEASED
9/10/18

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (2N A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JJB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JJB		
CHECKED	JJB	DRAWING NO. D2252	REV. G
MFG. APPR.	JJB	SHEET 1 OF 6	
APPROVED	JJB	TITLE BASKET ASSEMBLY (206L)	SCALE NTS
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DATE	09.02.03		

10 0.13
G 2 PL, REF



WELD ALL JOINTS
AS SHOWN

D2252-1

G D2327-3
REF
SEE DETAIL F
B2-5

10 48.00
REF G

D3749-1
3 PL G

D2221-1 G

D2252-7
D2252-23

D2252-1

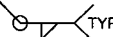
25.50
REF

31.19

G D2989-19

31.19

D2581



D2581

30.00
9

34.50
9

30.00
REF
9

96.00±0.13 G

A

A D7-5

RELEASED
9/2/18

LID FRAME NOTES:

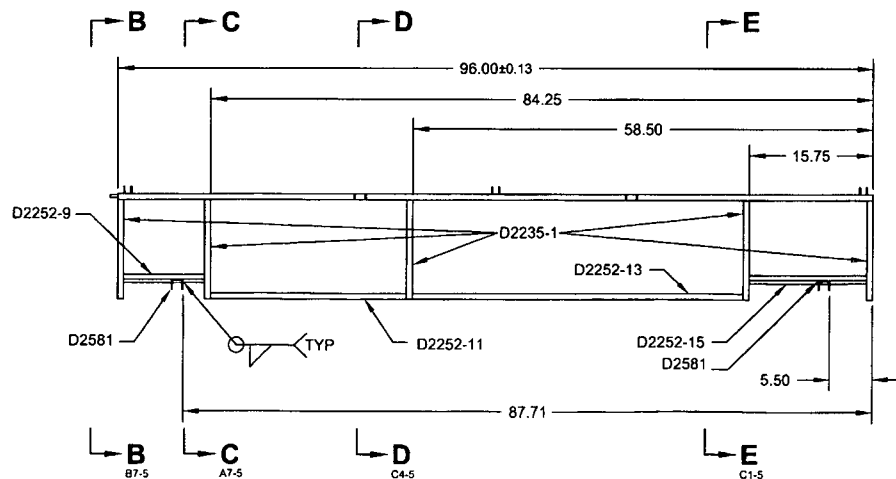
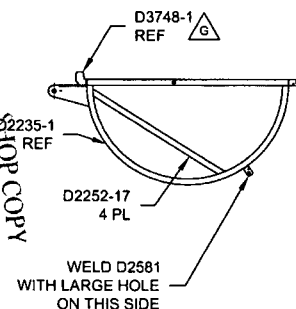
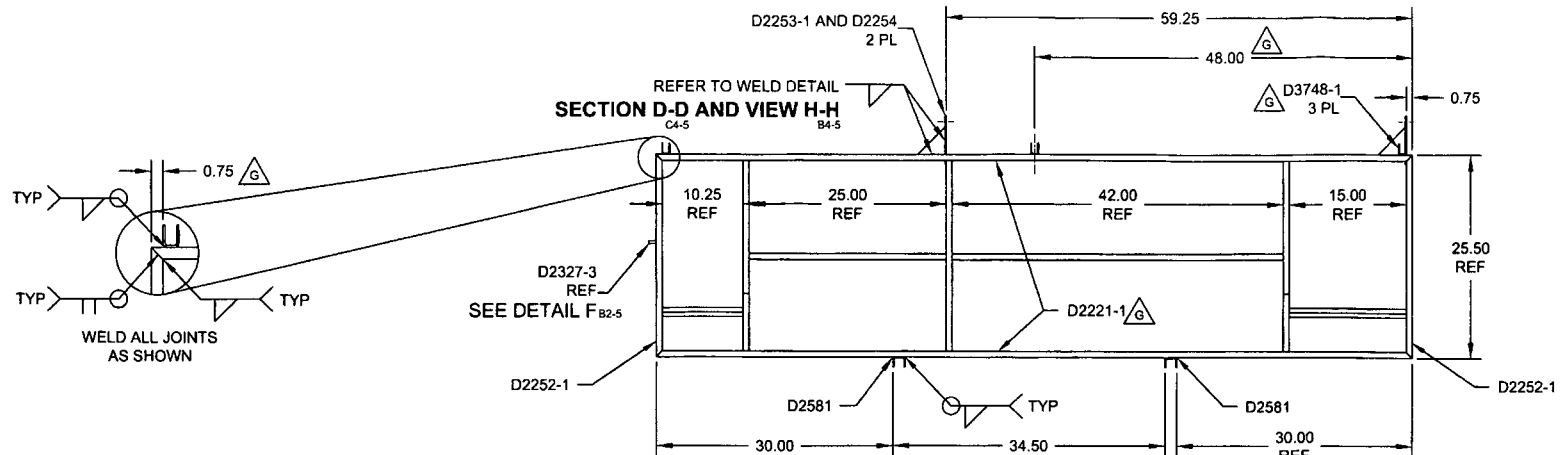
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

G

D2252-043 LID FRAME

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MFG. APPR.		D2252	SHEET 2 OF 6
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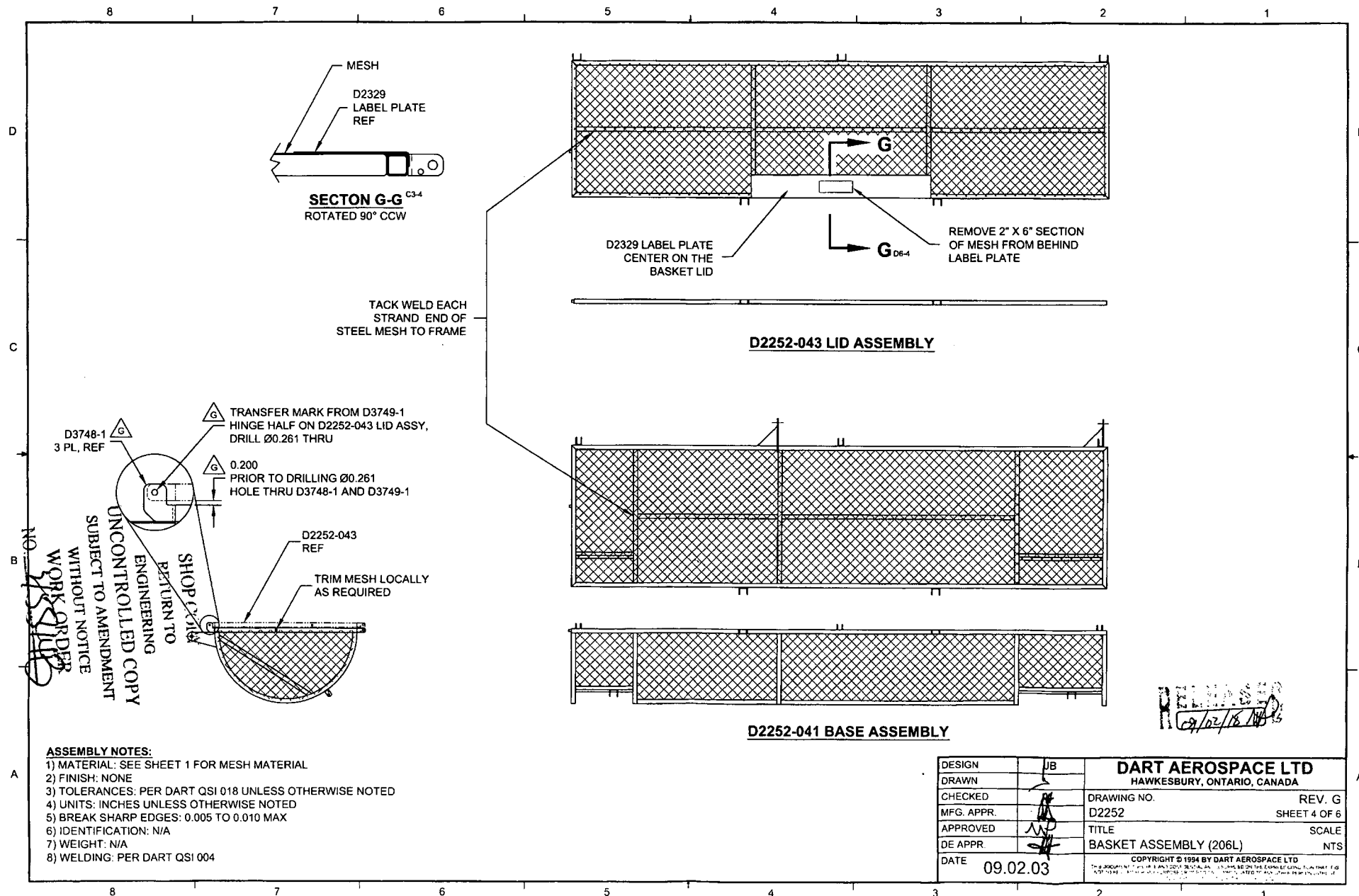
D2252-041 BASE FRAME ASSEMBLY

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- BASE FRAME NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004

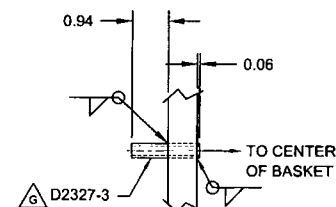
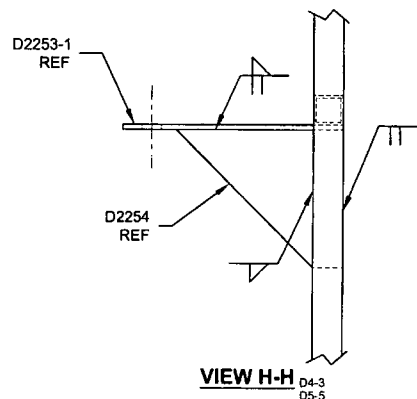
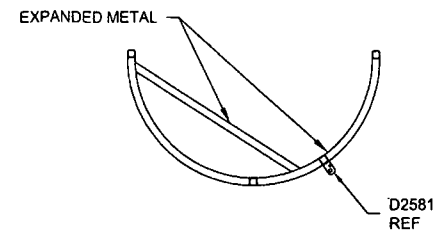
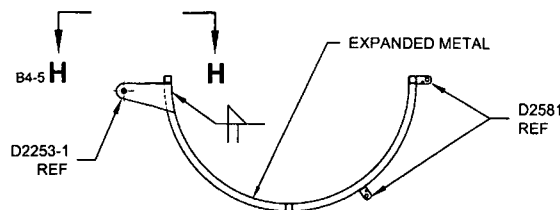
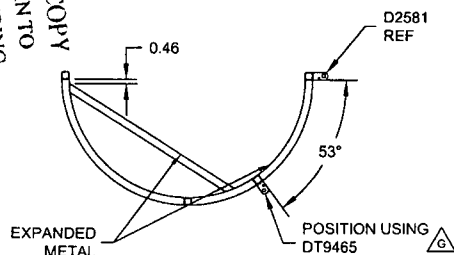
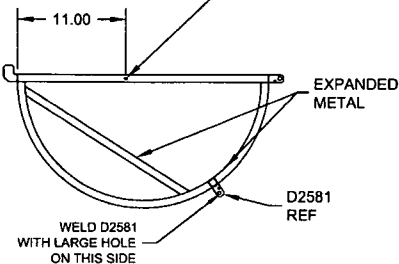
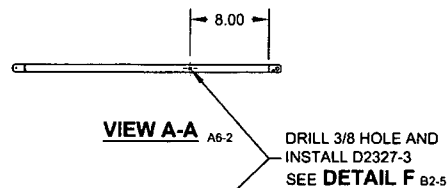
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8 7 6 5 4 3 2 1



DETAIL F C5-3
SPACER INSTALLATION C6-2

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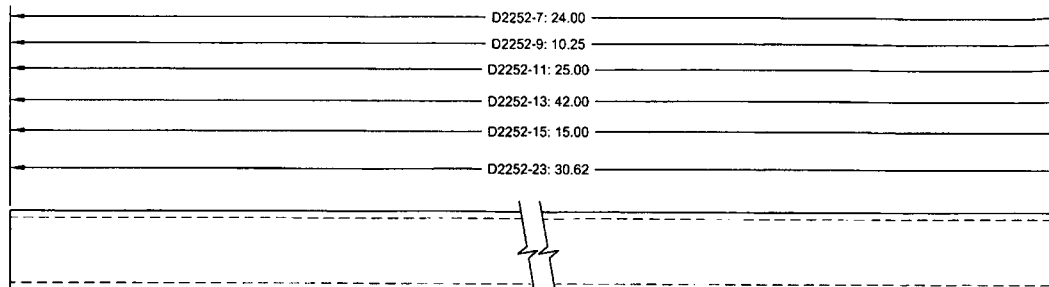
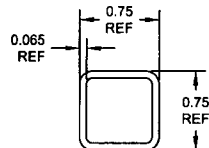
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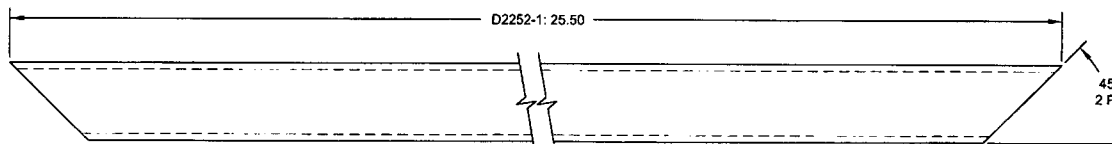
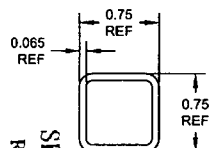
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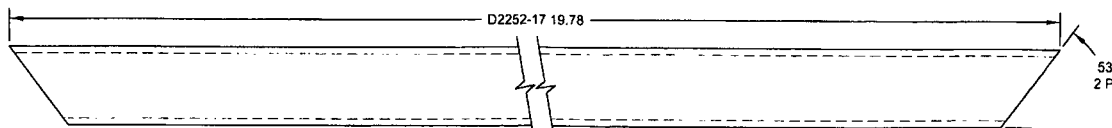
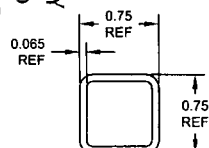


D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME

C



D2252-1 FRAME



D2252-17 FRAME

- NOTES:
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

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8 7 6 5 4 3 2 1

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